

Date: Monday, 05/11/2007 8:58:09 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
 Job Number : 35515
 Estimate Number : 10804
 P.O. Number : N/A
 This Issue : 05/11/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LANDING GEAR
 Previous Run : 00015
 Written By :
 Checked & Approved By :
 Comment :

Drawing Name : ~~D206-667-2063A~~ ARMOR SHIELD
 Part Number : D206667203A
 Drawing Number : REWORK-ARM.SHIELD
 Project Number : N/A
 Drawing Revision : N/A
 Material : N/A
 Due Date : 12/11/2007 Qty: 1 Um: Each

Additional Product

Job Number:



DART		TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D206-667-103A	CHG	CHG001
DESC	Crosstube Fwd High	SIC	SH01-5
LOT	B35027	SIC	SR01304NY
MODEL	Bell 206L/L1/L3/L4	SIC	
MADE IN CANADA			

Seq. #: Machine Or Operation: Description :

1.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

REMOVE FROM STOCK:

1 X D206-667-103A ~~2063A~~

STRIP p746 ARMOR SHIELD

ml 07 11 05

①

2.0 D206667203A Crosstube Installation W/ armour shield



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Crosstube Installation W/ armour shield

3.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING
 RE-SPARY PAINT CROSSTUBE
 WHITE IMRON PER QSI 005 4.2

APPLY NEW ARMOR SHIELD
 PER DSI 9326 REV.B

ml 07 11 07

Pro

4.0 QC14 INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

ml 07 11 10

07-11-13 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/11/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/10	3.0	Strip Armor shield + Paint off x-tube	<i>[Signature]</i>	Repaint and re-apply <u>new</u> armor shield	<i>MM</i> 07/11/10	<i>[Signature]</i> 07-11-13	<i>[Signature]</i> 07-11-12	<i>[Signature]</i> 07-11-01

NOTE: Date & initial all entries

Date: Monday, 05/11/2007 8:58:09 AM
User: Linda Lâcelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-667-2063A

Job Number: 35515

Part Number: D206667203A

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

REASSEMBLE PER DRWG D206-667-243

USING EXISTING HARDWARE

RECORD ANY NEW HARDWARE:

CLAMP: MS21920-20x1 B102787

Abrasion Strip D2856-400 (cut to 7.73") B34642

ml 071108

①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ja-11-13 ①

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP

ENSURE ORIGINAL KIT IS IN BOX.

DDH

Cojula, S (1)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20111116 ①

Job Completion



u 071116

→ 7.1 Ja-11-15 chg002

DART		TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL 408-99			
P/N	D206-667-103	CHG	CHG002
DESC	Crosstube Fwd High	SIC	SH01-5
LOT	B35515	SIC	SR01304NY
MODEL	Bell 206L/L1/L3/L4	SIC	
MADE IN CANADA			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

To further protect Dart crosstubes from mechanical damage in service, they may be treated with "Armor Shield" surface treatment. To designate crosstubes with 'Armor Shield' add 'A' to the Part Number. For example, D206-667-101A is a D206-667-101 crosstube coated with Armor Shield. The Change Number of Dart crosstubes with "Armor Shield" is affected as per above table. It is acceptable to apply the Armor Shield in regions shown in Figure 1 or Figure 2 only. It is **NOT** acceptable to apply Armor Shield in the cuff and support/clamp regions.

INSTALLATION	STC		CHANGE NUMBER	
	CANADIAN	FAA	DSI 9326 REV. A (Proform PF746/746-1 Treatment)	DSI 9326 REV. B (BCG4 Treatment)
D205-596-101A/-103A/-105/-107A	SH03-6 ISSUE 3	SR01742NY	CHG 001	CHG 002 (or later)
D212-664-101A/-201A D412-664-203A D412-664-105A/-205A	SH01-9 ISSUE 3	SR01298NY	CHG 002 (or earlier) CHG 004 (or earlier) N/A	CHG 003 (or later) CHG 005 (or later) CHG 001 (or later)
D206-667-101A/-103A/-201A/-203A D407-667-105A/-205A	SH01-5 ISSUE 3	SR01304NY	CHG 001 CHG 002 (or earlier)	CHG 002 (or later) CHG 003 (or later)
D058-676-101A/-201A	N/A	SR01018SE	CHG 001	CHG 002 (or later)
D350-748-101A/-201A	SH06-27 ISSUE 1	SR02359NY	N/A	CHG 001 (or later)

1.0 TO APPLY ARMOR SHIELD

- 1.1 Ensure the crosstube is appropriately finished in accordance with the relevant manufacturing drawing or Instruction for Continued Airworthiness (ICA).
- 1.2 Clean/degrease surface of crosstube using Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser, or equivalent and wipe the surface to clean the entire area
- 1.3 Mask areas around supports and cuffs per Figure 1 or Figure 2 (D350-748-101/-201 only). Abrade paint finish in areas requiring protection using 800 grit sandpaper. Ensure the surface is de-glossed.
- 1.4 Re-clean the surface per Step 1.2.
- 1.5 Mix BCG4 Component A and BCG4 Component B in accordance with manufacturer's instructions.
- 1.6 Apply 5 wet coats in accordance with manufacturer's instructions.
- 1.7 To avoid hard tape line, unmask immediately after application of last coat.
- 1.8 Allow BCG4 to dry in accordance with manufacturer's instructions.

2.0 ARMOR SHIELD REMOVAL / RE-APPLICATION

To remove the Armor Shield coating or if damage to the coating and/or crosstube is observed during inspection.

- 2.1 Remove Armor Shield from the affected area using 80 grit sandpaper. To remove Armor Shield from larger areas, bead blasting has been determined to be the most effective technique.
- 2.2 Repair mechanical damage (within limits) to the crosstube and touch up finish in accordance with the relevant ICA.
- 2.3 Apply Armor Shield in accordance with Section 1.0 of these instructions.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01 APPROVED  BY: D. SHEPHERD (DE # 02) DATE: 07.10.17 CERT. NO.: SEE TABLE ISSUE NO.: SEE TABLE

B	BCG4 REPLACES DISCONTINUED PROFORM PF 746 OR PF 746-1; ADD D350-748-101/-201	MB	07.10.17
A	NEW ISSUE	PH	06.02.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. B DSI 9326 SHEET 1 OF 2 TITLE SCALE ARMOR SHIELD NTS	
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.10.17		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

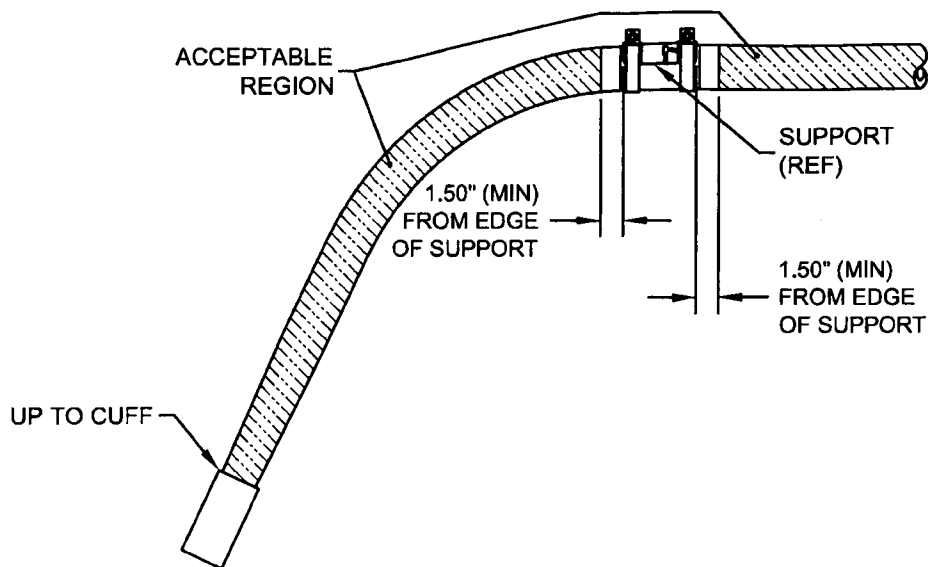


FIGURE 1 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD
(SEE FIGURE 2 FOR D350-748-101/-201 CROSSTUBES)

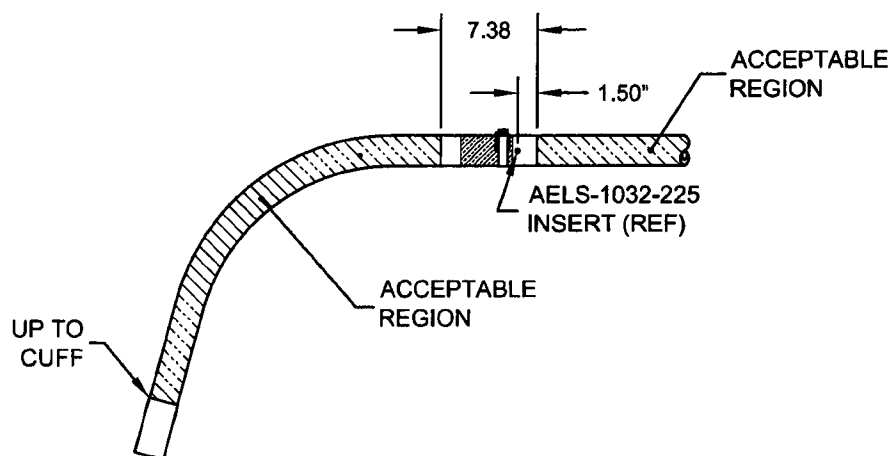


FIGURE 2 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD
(D350-748-101/-201 ONLY)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)
DATE: 07.10.17
CERT. NO.: SEE TABLE
ISSUE NO.: SEE TABLE

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	EE	DSI 9326	SHEET 2 OF 2
APPROVED	J	TITLE	SCALE
DE APPR.	J	ARMOR SHIELD	NTS
DATE	07.10.17	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26 #**UNDER REVIEW**

06.07.10 R4

re draw detail F

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

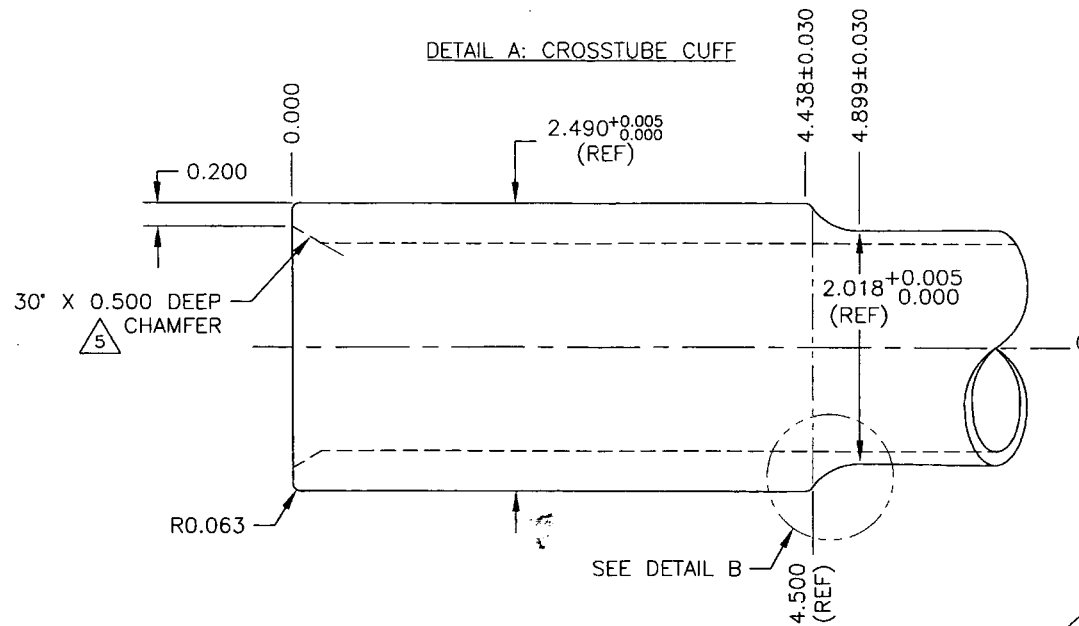
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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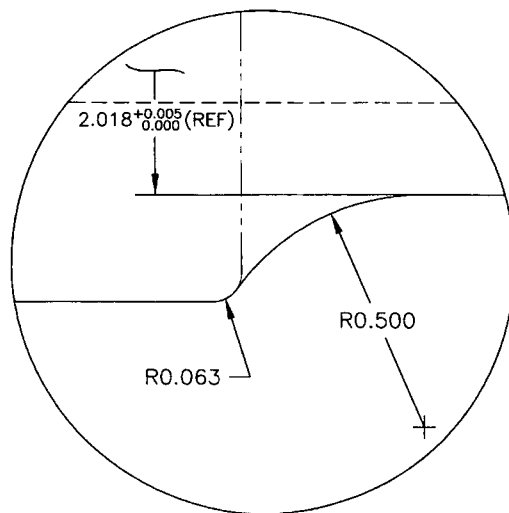
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DETAIL A: CROSSTUBE CUFF



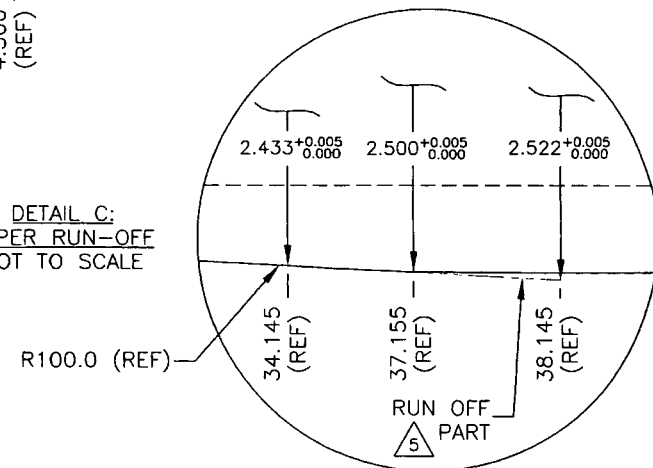
05.07.26

UNDER REVIEW
06.03.10 PH
re-draw detail F



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C: TAPER RUN-OFF NOT TO SCALE



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DESIGN	PH	DRAWN BY	PH	DART	DART AEROSPACE LTD. WARRICKBURGH, ONTARIO, CANADA
CHECKED	DS	APPROVED	DS	DRAWING NO.	D206-667-243
DATE	05.07.26	TITLE	CROSSTUBE ASSY (206L HIGH AFT)	REV. B	SHEET 3 OF 3
		SCALE	1:1		